

# Work Order ID 59759

Thursday, June 10, 2010 2:44:33 PM



Page 1

Item ID:	D3083-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Placard				Stop	
Start Date:	6/10/2010	Start Qty:	10.00			
Required Date:	6/18/2010	Req'd Qty:	10.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>10/6/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3083	Rev A								

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>12006</u> <input type="checkbox"/> D3083-1 Placard as per Dwg D3083 <input type="checkbox"/> Material: White Letters on black adhesive back manufactured from 3M 7 MIL masking film # 8522CP or Avery IPM # 2031 <input type="checkbox"/> Possible Supplier: Studio Lettrage <input type="checkbox"/> Material release note is required								

CL 10/6/11 10

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure material release note is attached								

PC 10/6/11 (10)

120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									

8/10/06/15

(+10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59759**

Thursday, June 10, 2010 2:44:33 PM

Page 2

Item ID: D3083-1

Accept

Revision ID:

Item Name: Placard

Start Date: 6/10/2010 Start Qty: 10.00

Required Date: 6/18/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 36

0.00



Packaging

Memo

0.00

Packaging

10-6-15

sf 100

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10  
ms 10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3083	REV. A SHEET 1 OF 1
DATE 02.01.20		TITLE PLACARD	SCALE NTS
A	02.01.20	NEW ISSUE	

RELEASED  
02.01.20 A

REFERENCE ONLY

PULL TO  
DEPLOY MIRROR.  
PUSH TO STOW  
ABOVE 90 KIAS.

W/ 59759

D3083-1 PLACARD

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK  
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP  
OR AVERY IPM # 2031  
MAXIMUM SIZE IS 0.85" WIDE X 0.55" HIGH

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO12066**

Purchase Order Date 6/11/10

PO Print Date 6/11/10

Page Number 1 of 1

**Order From :**

VC-STU001

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

**Contact Name**

**Vendor Phone**

613 632 5449

**Vendor Fax**

613 632 9491

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
*6/11/10*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3083-1P	PLACARD	6/15/10 Yes	10.00 Each	Yours ppd	\$5.0000	\$50.00

**Special Inst:** AS PER DWFG D3083 REV. A  
B59759

**PO Total:**

**\$50.00**

**CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY**

*u CL*

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

**Change Nbr:** 1

**Change Date:** 6/11/10



DE LETTRAGE 2001

210 MAIN W.,  
HAWKESBURY, ONT.  
K6A 2H6

Tel.: 613 632-2001  
Fax: 613 632-9491  
www.studiolettrage.com

INVOICE / FACTURE

VENDU À:  
SOLD TO:

LIVRÉ À:  
SHIPPED TO:

No.: 14023  
DATE: 06/14/2010  
PAGE 1 of 1

Re: Quote No. 9021

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario  
K6A 1K7

Dart Aerospace Ltd  
Hawkesbury, Ontario

ITEM ARTICLE	QTY QTE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMOUNT MONTANT
	10 1		D3083-1P set up printing E - GST @ 5% GST PST Exempt: #6122-5207	E E		5.00 25.00	50.00 25.00  3.75
dio de Lettrage GST: #869034678RP001						TOTAL	78.75

12066

J By.

erci! Thank You!





# Scotchcal™

## Opaque Imaging Media 8522

### Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

### Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlamine can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

### Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

## Product Bulletin 8522

Release F, Effective January 2003  
Black bar in margin indicates a change

- Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

### Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

## Compatible Products and Equipment

### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

### Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

### Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

### Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

### Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

## How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at [www.scotchprint.com](http://www.scotchprint.com)

### Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

### Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

### Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

### Fabrication

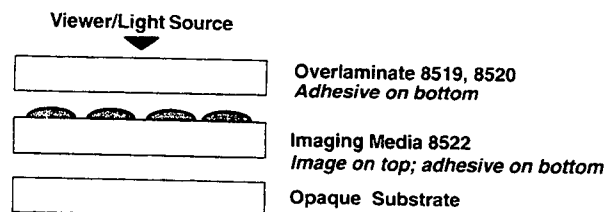
Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

## Graphic Construction Options

### Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.



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